

Work Order ID 106749

September-25-13 9:20:01 AM

106749

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Item ID: D3016-17

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gusset

Start Date: 9/11/13 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/02/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJDate: 13-09-25 Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3016	Rev A

100 0.00

100 FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo 0.00

1-Cut as per Dwg D3016 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary40 0 Jm13-09-25

110 0.00

110

QC

Quality Control

Memo 0.00

40 0 Jm13-09-25

120 0.00

120

QC

Quality Control

Memo 0.00

5hr
B92S40 _____

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Item ID:	D3016-17	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Gusset						
Start Date:	9/11/13	Start Qty:	40.00	*40*	Cust Item ID:		
Required Date:	10/02/13	Req'd Qty:	40.00	*40*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Packaging	0.00				40		EL 13-9-21	
Packaging	Memo	0.00							
	Identify and bag with light oil (Vactra oil #2), then Stock *****STOCK IN LARGE FAB***** Location: <u>w/A ooi</u>								
140 *140* QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

JH/LM 13/09/30

AB/ajt

Picklist Print

September-25-13 9:20:04 AM

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Work Order ID: 106749

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D3016-17

Parent Item: D3016-17

Parent Item Name: Gusset

Start Date: 9/11/13

Required Date: 10/02/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP B03.05.09ReformatKJ/RF
IPP Rev:C 08-04-11 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049		Purchased	No			100	sf	120.5903	0.0173	0.72842		**	

M4130NS 049

4130 Sheet .049

Location	Loc Qty	Loc Code
MAT020	120.590263	
11612	4.2	
123049	17.340263	
124283	99.05	124283

JmB-09-25

DART AEROSPACE LTD	Work Order:	106749
Description: Gusset	Part Number:	D3016-17
Inspection Dwg: D3016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Jn	Audited by:	ShB	Prototype Approval:	N/A
Date:	13-09-25	Date:	R 9 25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.11	New Issue	KJ/DD	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

106749 M15
13-09-16

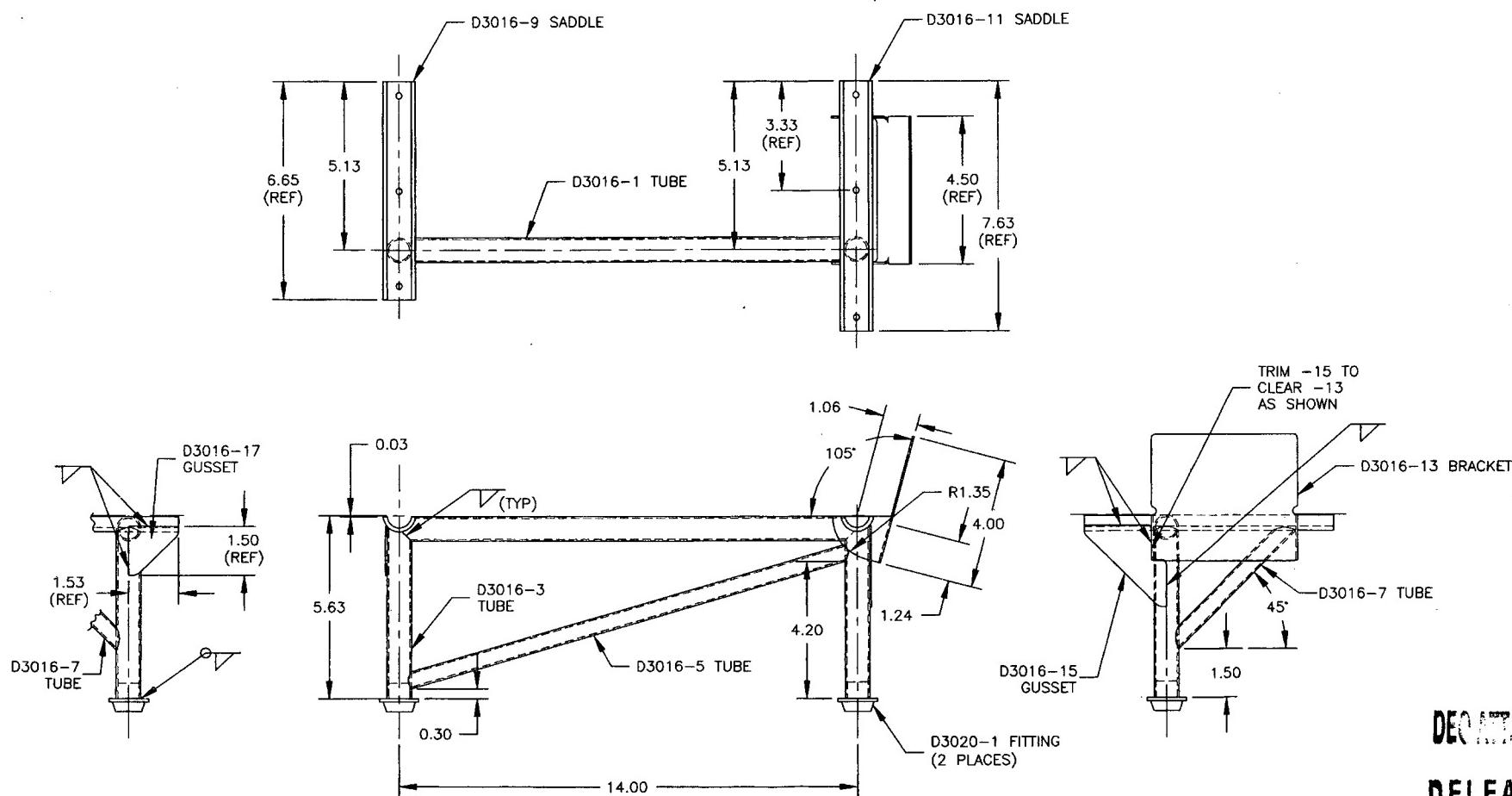
DEO ATTACHED

RELEASE
01.05.30

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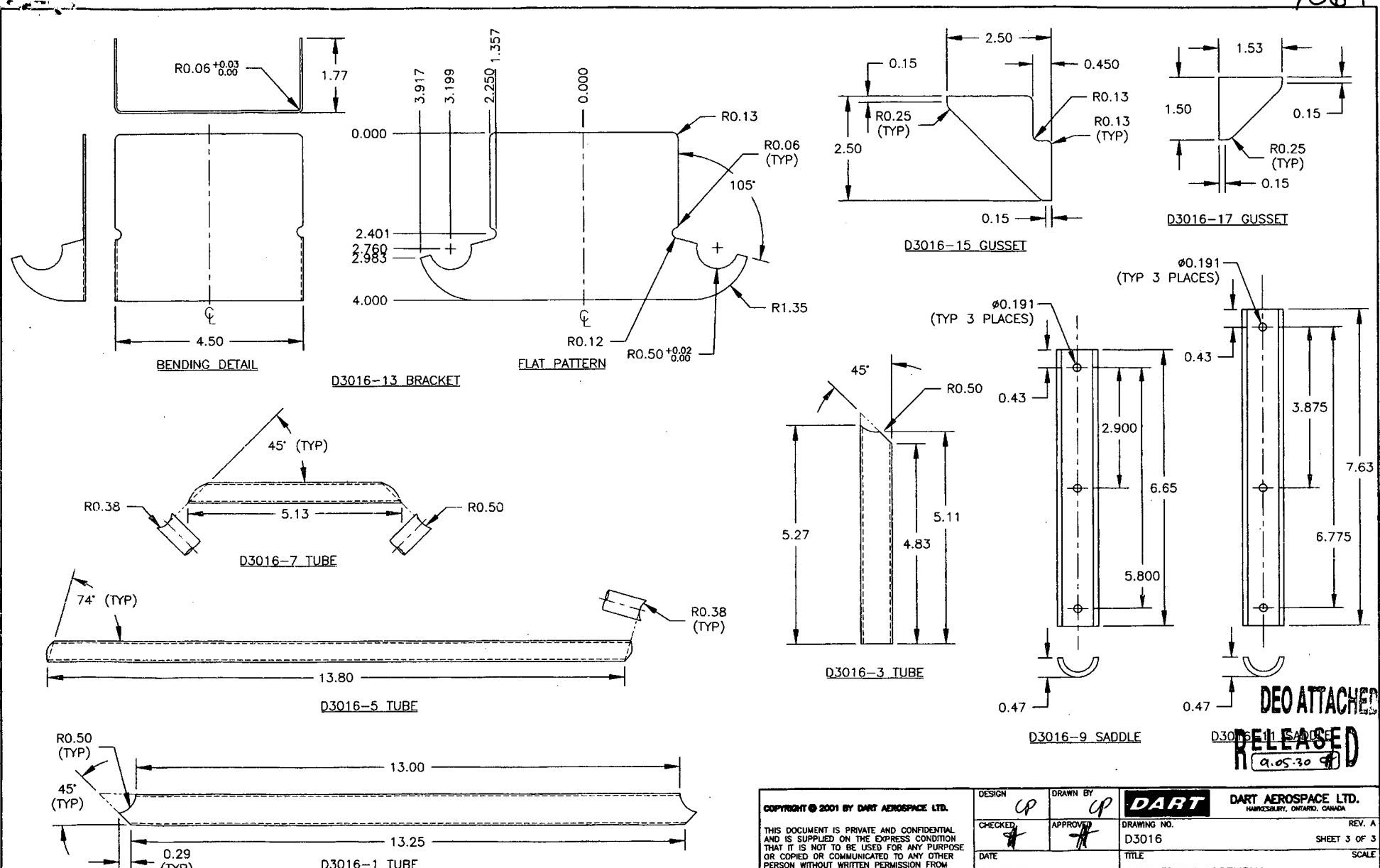
106749

D3016-041 SEAT FRAME ASSEMBLY

DETACHED
RELEASED
01-05-30

COPRIGHT © 2001 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	UP	<i>[Signature]</i>	APPROVED	DRAWING NO. D3016
DATE	01.05.18	SHEET 2 OF 3	TITLE	SCALE	1:3

106749



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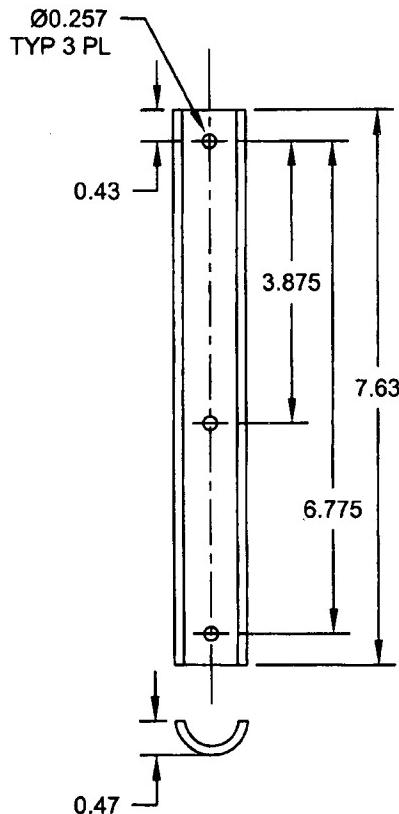
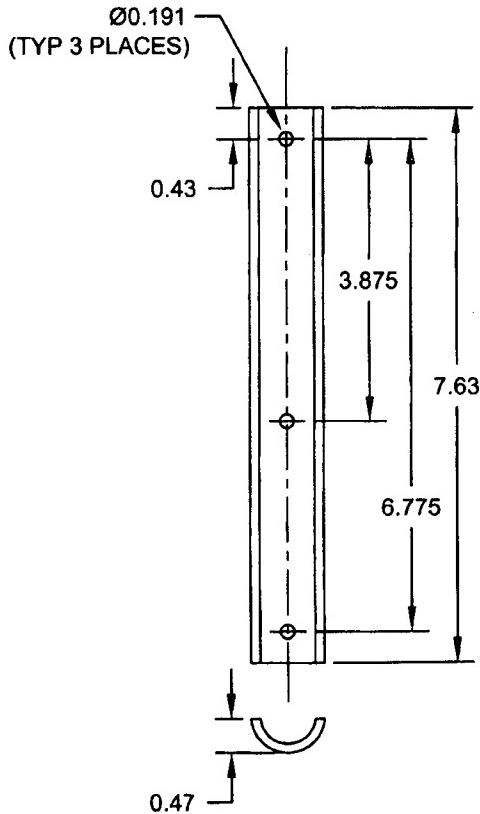
DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN	CHECKED <i>(P)</i>	MFG. APPR. <i>(P)</i>	APPROVED <i>(MAP)</i>	DE APPR. <i>(MAP)</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:D3016-11 SADDLEWAS:D3016-11 SADDLE